	Work Order ID 105333		*105333*									Page 1
Item ID: Revision ID:	D2232-1	2 32-1	1	Accept	*N	1900	040	100)* s	etup Sta	1 71	S1*
Item Name:	Basket Hinge		,		:					Sto	P *N	S2*
Required Date:	8/01/13 8/01/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*			Cust Item I Customer:	D:					
Reference:									R	lun Sta	rt *NI	R1*
Approvals:	Process Plan	n:MLゴ	Date: 13-08-06			D:	ate:			Sto	n	
	QC:		Date:	SPC (Y/N):		D:	ate:				" *N	R2*
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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D2232	Rev	С										
100				0.00		THE RESERVE THE PROPERTY OF TH			30			
100		FLOW WATER JET							TO			Jm3.09-16
Waterjet FLOW CNC Waterje	et	Memo 1-Cut as per Deburr if ne	Dwg D2232 Dwg Rev:_ cessary	Prog Rev:	2-							
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00					20			
110 QC Quality Control		Memo	ı	0.00					20			Jm13-09-16
120		QC8- Inspect parts - seco	and check	DAS 0.00 27 9-89					20			
120 QC Quality Control		Memo		0.00 B & .	16				<u> </u>			

WORK ORDER NON-CONFORMANCE / UPDATI

DQA: Date:

ICR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE											
								QA Closed:	Date	•	
r:				DISPOSITION			AGAINST DE	PARTMENT	/PŖQCESS		
				Rework]	Skid-tube Crosstube			Water Jet	Engineering	
0.				Scrap]	Machining Small Fab			d. Eng. Coor.	Quality	
				Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other	
0				Work Order Update Large Fab Composite			Composite	ite Supplier Supplier			
			Descri	ption of work order update	Initial	A	ction	Sign &			
Date	Step	Qty	(or Non-conformance	Chief Eng	g Des	cription	Date	Verification	QC Inspector	
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-			' 	Finish	\blacksquare	*.					
	g Gear Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque W	Date Step Date Step Date Step Bending Centre Not Concer Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Ripples in Bend Torque Waves in E	Date Step Qty Date Step Qty Gear Bending Centre Not Concentric to Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	Description Date Step Qty Description Des	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance General Bending Bend BoM/Route Broken/Damaged Burrs Cracks Broken/Damaged Burrs Crushed/Crimped Burrs Cuffs Contamination Heat Treat Countersink Inspection Strip in Tube Ripples in Bend Drill Holes Torque Waves in Extrusion Drawing	DISPOSITION Rework Scrap Use-as-is Work Order Update Or Non-conformance Chief English Bending Bend Grain Bend Grain BoM/Route Burrs Instruction Cracks Broken/Damaged Instruction Grain Bom	DISPOSITION Rework Scrap Use-as-is Work Order Update On Non-conformance FAULT CATEGORY Gear General Bending Centre Not Concentric to O/S Broken/Damaged Inspection Incomplete Crushed/Crimped Burss Instructions Incomplete Crushed/Crimped Burss Instructions Incomplete Cuffs Countersink Mislabeled Inspection Strip in Tube Cut Too Short Misread Offset Torque Waves in Extrusion Drawing Orawing Oct of Calibration	DISPOSITION Rework Skid-tube Crosstube Machining Small Fab Small Fab Large Fab Composite	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Date Step Qty Description of work order update or Non-conformance Bending Centre Not Concentric to O/S Cracks Broken/Damaged Users Scrap Over/Under Cracks Broken/Damaged Unspection Incomplete Unspection Incomplete Unspection Strip in Tube Countersink Inspection Strip in Tube Recyston Drawing Users Bend Inspection Strip in Tube Recyston Drawing Users Bend Inspection Strip in Tube Recyston Drawing Users Brower Drawing Users Bend Inspection Strip in Tube Recyston Drawing Users Instructions Incomplete Part Loss/M Misread Power Loss/ Misread Drawing Unit Holes Drawing Out of Calibration	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update Or Non-conformance Bending Centre Not Concentric to O/S BOM/Route Hardware Crasks Broken/Damaged Crasks Broken/Damaged Users Instructions incomplete Users Instructions incomplete/Unclear Part Moved Part Instructions incomplete/Unclear Part Moved Positioned Wrong Power Loss/Surge Offset Out of Calibration DISPOSITION AGAINST DEPARTMENT/PROCESS Skid-tube Crosstube Water Jet Machining Small Fab Prod. Eng. Coor. Rec/Store/Packaging Supplier Crossitube Crosstube Machining Small Fab Prod. Eng. Coor. Rec/Store/Packaging Supplier Date Verification FAULT CATEGORY Sear General Bending Description Date Verification FAULT CATEGORY Gear General Bending Description Date Verification FAULT CATEGORY Gear General Bending Date Verification Facility and Company Supplier Date of Conference Part Incorrect Part Moved Positioned Wrong Power Loss/Surge Offset Out of Calibration Torque Waves in Extrusion Drawing Out of Calibration	

Outside Dimensions

Wave/Twist in Tube

Folio

Work Order ID 105333 August-01-13 11:23:50 AM				*105				Page 2				
Item ID: Revision ID:	D2232-1		· A	Accept	*N900	040	10	N *	Setup	Start	IA	S1*
Item Name:	Basket Hinge									Stop	*N	S2*
Start Date:	8/01/13	Start Qty: 12.00	*12*		Cust Item I	D:						
Required Date	: 8/01/13	Req'd Qty: 12.00	*12*		Customer:							
Reference:												
Approvals:	Process Pla	an: .	Date:	Tooling:	Da	ıte:			Run	Start	"IV	R1*
	QC:	West - 17	Date:	SPC (Y/N):	Da	ıte:		-		Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description Identify as per dwa & Sto	ck Location: WHO 9	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	ject y	Reject Number	Insp. Stamp
130		identify as per dwg & ord	ok Education. <u>Corv</u>	0.00				200 X				\sim
Packaging		Memo		0.00								2 g 1
Packaging		*****STOC	K IN BASKET CELL*****								,	5-1-/
140		QC21- Final Inspection -	Work Order Release	0.00						1	1 ~	10 -
140									12	319	118	711
QC		Memo		0.00				***************************************	` - /	1	1	
Quality Control												

#130an

NCR: Ye	es / No				WORK ORDER NON-C	CON	FORN	MANCE / UPDATE				
										QA Closed:	Date	2:
Nork Order	ŕ:				DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
Part No	0.			······································	Rework Scrap Use-as-is	Scrap Machining Small Fa		ab Prod. Eng. Coor. ng Rec/Store/Packaging			Engineering Quality Other	
NCK INC	U				Work Order Opulate	¹		composit	ــــا	1	20ppile: [
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	1	nitial ef Eng	Action Description		Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling perator flaterial etup ther rocess upplier raining napproved												
парріочеа			<u> </u>	<u> </u>	F	AUL	T CATE	GORY				
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Landin	Bending Centre I Cracks Crushed Cuffs Heat Tro Inspecti Ripples	Not Conce I/Crimped eat on Strip in	ı Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instructi Mainte Mislabe Misread Offset Out of C	on Incomplete ions Incomplete/Unclear enance eled I		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Turning	Sequence	•		lFinish	1 1	Out of S	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

August-01-13 11:23:50 AM

Work Order ID:

105333

Parent Item:

D2232-1

Parent Item Name:

Basket Hinge

Start Date: 8/01/13

Required Date: 8/01/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPPB01.06.07Now laser cutEC

IPP Rev:C Now on Waterjet 06-11-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	286.1533	0.0243	0.3069468 O.S	,	Jm	13-09-16

Location	Loc Qty	Loc Code
MAT020	286.1532632	_
122521	19.1432632	
124445	93	•
M126075	174.01	

124445

NCR; Y	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:												
Work Orde	er: _			-		DISPOSITION Rework	٦		Skid-tube	AGAINST DE] [
Part N	-					Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Pro Rec/Stor	Engineering Quality Other			
Root						ption of work order update	1	Initial	Acti		Sign &		
Cause	_	Date	Step	Qty		or Non-conformance	C	nief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								LT CATEG					
							AUI	LICATE	JUNT				
Landir		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in ı Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/U enance eled		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque W	laves in E	extrusio	n [Drawing		JOut of C	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	105 333
		,
Description: Basket Hinge	Part Number:	D2232-1
Inspection Dwg: D2232 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

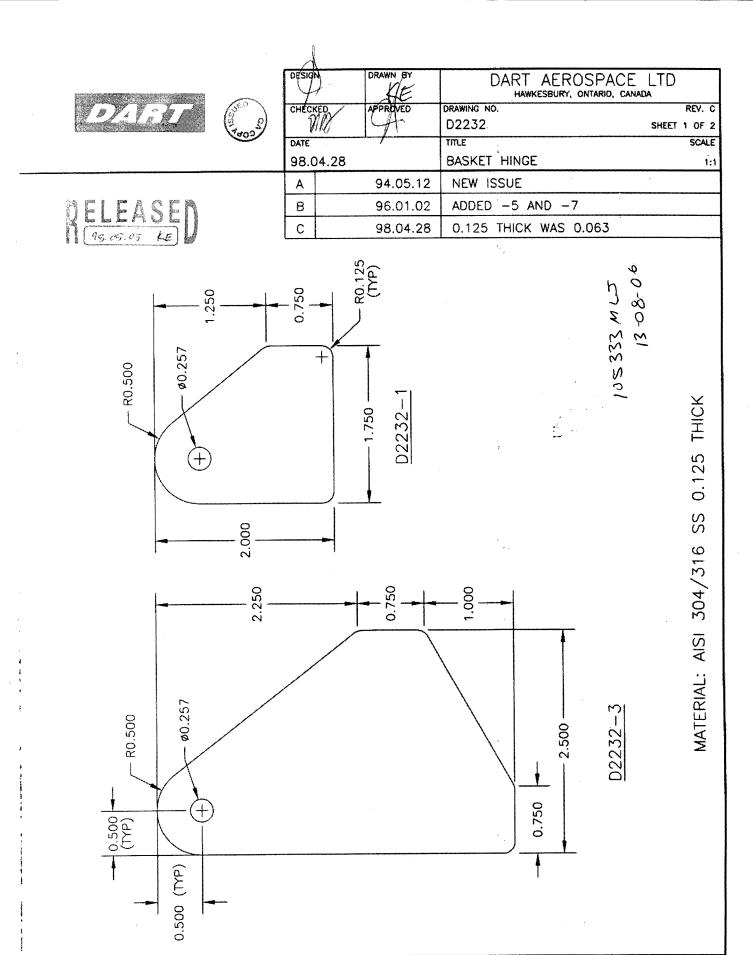
X	First Article	Prototype	
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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0.750	+/-0.010	0.750			J	
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Measured by: Jr Audited by: 9-89 Prototype Approval: N/A

Date: 13-09-76 Date: 13 Date: N/A

Rev	Date	Change	Revised by	Approved	l
Α	07.05.10	New Issue	KJ/JLM of	R	
			7 ()		,

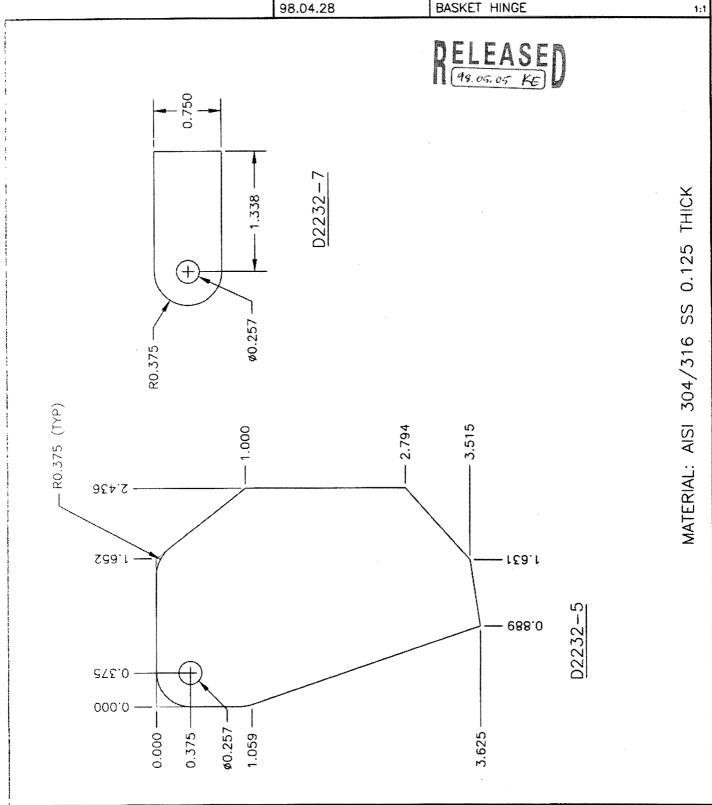


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DESIGN	DRAWN BY	DART AEROSPACE L HAWKESBURY, ONTARIO, CANADA	
CHECKED /	APPROVED	DRAWING NO.	REV. C
MY		D2232	SHEET 2 OF 2
DATE	' ' ')	TITLE	SCALE
98.04.28		BASKET HINGE	1:1



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